



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2432

Job Sheet 171553



Part No: D2432

Job Qty: 24 ea

Part Name: Bearpaw 19" X 24"



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/2/18

Job Tracking No:

Created By: Michelle Gagnon-Donovan

Due Date: 2/19/18

Type: Stock

Description:

Note: DWG REV H IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea		2/15/18	0.00	0.00	Start Up Container		18/04/17
120	Waterjet	24 pcs		2/16/18	0.00	6.19	Waterjet1		18/04/17
130	CNC Vertical Machining	24 pcs		2/19/18	0.36	30.81	HAAS 1		52 18/05/14
140	QC	24 pcs		2/19/18	0.00	0.00	QC2		9-89 18/05/14
150	QC	24 pcs		2/19/18	0.00	0.00	QC8		
160	Packaging	24 pcs		2/19/18	0.00	0.00	Packaging3		
170	QC21-SA	24 Ea		2/19/18	0.00	0.00	QC21		MAY 14 2018

Part Op 120 - Cut Blank as per D2432 File

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	88.8000 sf (3.7 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	89	1,865	0

Part Specifications

Specifications could not be found.



DART Aerospace Ltd.
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Container No: S062083



Part: D2432

Job No: 171553

Serial No/Batch: S062083

Revision:

Inspector:

Date: 04/17/18

2/10
25
17/18

DART AEROSPACE LTD		Work Order: <u>715</u>
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432 Rev: H		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.063 x 45°	+0.030/-0.010	0.063 x 45°	/		vern	mm L-05
B 0.200	+/-0.030	0.200	/		↓	
C 0.25 x 45°	+/-0.030	0.250 x 45°	/		↓	
D R0.250	+/-0.030	0.250	/		FG	
E 0.250	+/-0.010	0.245	/		vern	mm L-05
F 0.625	+/-0.030	0.620	/		↓	
G 0.375	+0.030/-0.010	0.380	/		↓	
H 0.950	+0.030	0.950	/		↓	
I 19.000	+/-0.030	19.00	/		tape	
J Ø0.260	+0.005/-0.000	0.260	/		vern	mm L-05
K Ø0.93	+/-0.030	0.931	/		↓	
L 0.30	+0.030/-0.000	0.315	/		↓	
M 23.750	+/-0.030	23.750	/		tape	
N 2.000	+/-0.030	2.014	/		vern	mm L-05
O 0.38	+/-0.030	0.375	/		"	
P						
Q						
R						
S						
T						
U						
V						

Measured by: <u>Theresa</u>	Audited by: <u>P</u>	Preliminary Approval:
Date: <u>12/5/11</u>	Date: <u>18-05-14</u>	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	
E	15.02.09	Dimensions revised	KJ	<u>[Signature]</u>